



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4634-145
Job Sheet 167078-A



Part No: D4634-145

Job Qty: 1 ea

Part Name: Aft, Center Ceiling Replacement Panel Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/24/17

Job Tracking No:

Due Date: 11/10/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea		11/9/17	0.00	0.00	Start up container	
100	HandThermo	1 pcs		11/9/17	0.00	1.65	HandFinish4	
110	Small Fab	1 pcs		11/10/17	0.00	1.47	Small Fab	
120	QC	1 pcs		11/10/17	0.00	0.00	QC5	
130	Packaging	1 pcs		11/10/17	0.00	0.00	Packaging3	
140	QC21-SA	1 Ea		11/10/17	0.00	0.00	QC21	

Part Op 100 - Pick Kit

Descriptions: 110 - Assemble as per Dwg D4634-145 Bond foam core to inside of panel 3M Scotch Weld 1300

Batch: 138615 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II. (see note 8) Batch # 138649 Expiry Date 12/01/28 3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer(see note 9) Batch: 135435

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location:

140 - QC21- Final Inspection - Work Order Release

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D4634-5	1	3	0	0
	D4636-5	1	43	0	0
	D4647-1	1	4	0	0
	D4664-5	6	39	0	0
	D4712-1	1	4	0	0
	D4732-17	1	0	0	0
	D4732-23	1	1	0	0
	D4732-27	1	1	0	0
	D5021-5	1	1	0	0
	MPNY-750S-9-C	9	570	0	0
	MS20426AD3-4	4	5,055	0	0
	MS20426AD4-6	2	2,797	0	0
	MS21059L08	2	62	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS				
Part No. _____		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
NCR No. _____		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
		Large Fab ☐	Composite ☐	Supplier ☐		

Date : _____	Step #: _____	QTY Effective : _____	MRB (QSI042) Approval ☐
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Description Work Order Deviation S022941 Aft, Center Ceiling Replacement Panel Assembly D4634 - 145	Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com	Completed By _____
		Lead hand / Supervisor Approval Verification _____
		QC / QA Coordinator Approval _____

Root Cause		PART NO: Revision: Operation: Change No:		Start up Operation Mfg Date: 12/15/17 Job No: 167078-A	
Environment ☐	No I ☐	Design ☐	Oper ☐	Process/Program ☐	Positioned Wrong ☐
Doc/Data ☐	Offse ☐	Equip/Tooling ☐	Suppli ☐	Long Stock Pulled ☐	Outside Dimensions ☐
Handling/Pre ☐	Trainin ☐	Material ☐	Use for ☐	Out of Sequence ☐	Over/Under tolerance ☐
Internal Transport ☐	Poor Inf ☐	Internal Transport ☐	Poor Inf ☐	Off-set ☐	Part Incorrect ☐
Tribal Knowledge ☐	Rushing ☐	Tribal Knowledge ☐	Rushing ☐	Mislabeled ☐	Part Lost/Missing ☐
LOA ☐	Product In ☐	LOA ☐	Product In ☐	Fit/Function ☐	Part Moved ☐
Substation ☐	Process Imp. ☐	Substation ☐	Process Imp. ☐	Misaligned/off center ☐	Drawing ☐
Past Expiry Date ☐	Manufacturing Process ☐	Past Expiry Date ☐	Manufacturing Process ☐		Finish ☐
Misidentified ☐	Past Due ☐	Misidentified ☐	Past Due ☐		Misread ☐
		OTHER : _____			